

What is claimed is:

1. A method of forming a molded plywood door skin, comprising the steps of:

providing a plywood board;

conditioning the plywood board with water;

5 disposing the conditioned plywood board in a contoured mold press

having a mold cavity; and

deforming the plywood board in the mold press using sufficient heat and

pressure to form a molded plywood door skin having contoured portions

corresponding to said mold cavity.

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2. The method of claim 1, including the step of closing the mold press at a predetermined closure rate.

3. The method of claim 2, wherein the predetermined closure rate is between about 3

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mm per minute and about 7 mm per minute.

4. The method of claim 1, wherein said conditioning step includes exposing the plywood board to steam in an atmospheric chamber.

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5. The method of claim 1, wherein said conditioning step includes exposing the plywood board to steam in a pressurized, sealed cavity.

6. The method of claim 5, wherein the plywood board is exposed to steam in the pressurized, sealed cavity for at least about 30 minutes during said conditioning step.
- 5 7. The method of claim 1, wherein said conditioning step includes soaking the plywood board in a water bath.
8. The method of claim 7, wherein the plywood board is soaked in the water bath for at least about 4 hours during said conditioning step.
- 10 9. The method of claim 1, wherein said conditioning step includes exposing the plywood board to a surface spray.
10. The method of claim 9, wherein said conditioning step further comprises using
15 surfactants to achieve a desired moisture pick-up.
11. The method of claim 1, wherein said conditioning step increases moisture content of the plywood board to between about 10% and about 40%.
- 20 12. The method of claim 1, wherein the plywood board is a luan plywood board.
13. The method of claim 1, wherein the plywood board includes an exterior ply of solid natural wood, and at least one interior core layer.

14. The method of claim 13, wherein the interior core layer is selected from the group consisting of medium density fiberboard, chipboard, oriented strandboard, softboard, hardboard, and particleboard.

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15. A molded multi-layer door skin, comprising:

a molded plywood substrate having at least one panel portion;

a molded depression surrounding and integral with said panel portion; and

an outer portion surrounding and integral with said molded depression.

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16. The door skin of claim 15, wherein said molded depression comprises an inclined wall extending downwardly from said panel portion to a depression base.

17. The door skin of claim 16, wherein said molded depression further comprises a contoured portion extending from said depression base to said outer portion.

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18. The door skin of claim 16, wherein said depression base is recessed from the plane of said outer portion between about 6 mm to about 9 mm.

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19. The door skin of claim 15, wherein the plywood door skin has a thickness of between about 2 mm to about 4 mm.

20. The door skin of claim 15, wherein said panel portion and said outer portion are coplanar.

21. The door skin of claim 15, wherein the plywood skin is formed from luan plywood.

22. The door skin of claim 15, wherein said plywood comprises an exterior solid, natural wood ply and at least one core layer.

23. The door skin of claim 22, wherein said core layer is formed from a wood composite selected from the group consisting of medium density fiberboard, oriented strand board, chipboard, hardboard, soft board, and particleboard.

24. A door, comprising:

first and second door skins, each door skin having an interior surface secured to a peripheral door frame and an exterior surface, at least one of said door skins being a molded plywood door skin having at least one panel portion, a molded depression surrounding and integral with said panel portion, and an outer portion surrounding and integral with said molded depression.